



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D4909-1
Job Sheet 171652



Part No: D4909-1

Job Qty: 2 ea

Part Name: Support



scrap

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/6/18

Job Tracking No:

Due Date: 2/9/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV A SHEETS 1,2 IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/8/18	0.00	0.00	Start Up Machining-3		JLM 2018/02/11
100	CNC Vertical Machining	2 pcs		2/9/18	0.74	0.00	HAAS1-5		JLM 2018/02/16
110	QC	2 pcs		2/9/18	0.00	0.00	QC2 Machining-3		JLM 2018/02/16
120	QC	2 pcs		2/9/18	0.00	0.00	QC8 Machining-3		
130	Packaging	2 pcs		2/9/18	0.00	0.00	Packaging3-2		
140	QC21-SA	2 Ea		2/9/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FB209
Descriptions: 130 - LOCATION : LG053

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4909-1TRN	Support Turning Detail	2 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4909-1TRN	2	8	0
	5038875			

Part Specifications

Specifications could not be found.

Plex 2/6/18 1:32 PM dart.leroux.jason



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Container No: S043383



Part: D4909-1

Job No: 171652

Serial No/Batch: S043383

Revision: D4909

Inspector:

Date: 02/16/18

5710

A: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>171652</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☒	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
Part No. <u>D4909-1</u>	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				
NCR No. _____								

e: 18-02-16 Step #: 100 QTY Effective: 2 MRB (QSI042) Approval

DAS
9
9-89

18-05-10

Description Work Order Deviation

Disposition

→ 3.550 to 3.560 dimension is
3.545 on 2 part
(1 blank makes 2 parts)
→ Operator didn't raise finish tool

Scrap and destroy
no replace.

Completed By

[Signature]

Lead hand / Supervisor
Approval Verification

[Signature] 18/02/17

QC / QA Coordinator
Approval

DAS
9
9-89

18-05-10

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	☒ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	☒ Over/Under tolerance		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Technical Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Fast Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER: _____					